

Date: Wednesday, 6/27/2007 1:10:14 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT FOR D206-642-511
Job Number : 33229	
Estimate Number : 12893	
P.O. Number : N/A	Part Number : K642 511
This Issue : 6/27/2007 S.O. No. : N/A	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 33097	Material : N/A
Written By : _____	Due Date : 7/10/2007 Qty: 3 Um: Each
Checked & Approved By : <u>JA 07.06.28</u>	
Comment : Est Rev: A 07.06.05 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-511 . CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

1 x D206-642-013 B 32401 (2)

3.0	D2652	Bushing
-----	-------	---------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

B32467

X

4.0	D2712	Set Screw
-----	-------	-----------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

29962

B31927

5.0	D29321	206 Saddle Left side
-----	--------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

B32377

7/7/259

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 33229

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

B31490 ✓

32399 ✓

7.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B31929 ✓

8.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B31793 ✓

B32469 ✓

9.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

B30480 ✓

B30281 ✓

10.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

B30482 ✓

B31250 ✓

11.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

B26772 ✓

32782 ✓

7/7/359 ✓

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

28926 ✓

✓

13.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

325707 ✓

✓

14.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

32409 ✓

✓

15.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

118919 ✓

✓

16.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 27.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

1101261 ✓

✓

17.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

1103324 ✓

1 7/7/2 SP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M103344 ✓

19.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M104817 ✓ M104537 ✓

20.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M103715 ✓ M104537 ✓

21.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M104603 ✓

22.0

AN5C15A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M100229 ✓

23.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M13918 ✓ 7/7/259

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 33229

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M18918 ✓

25.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918 ✓

26.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M104885 ✓

27.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

71 24 AN960C416L

Washer

M104542 ✓

28.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

71 8 AN960C516L

Washer

M103344 ✓

7/2/07 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 33229

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

29
M103691

34
M104532 ✓

30.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 39.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

30
~~M103691~~
M104603

34
~~M104532~~ ✓

31.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

M101419 ✓

✓

32.0

NAS1515H3L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H3L

Washer

41
M102492

34
M102536 ✓

33.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer

52
M103691

23
M104822 ✓

34.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

41

93
M103691

19
M104679 ✓

7/7/2 59 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 33229

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

16 NAS1515H5 Washer

35.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

④ Batch

8 NAS1515H5L

Washer

M103691 ✓ M104679 7/7/2 S9 ✓

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U 570705 6/7/15

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location:

7/7/6 Draft S9

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

③
R107107106

Job Completion



U 87-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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